

Work Order ID 163170

163170

Page 1

Thursday, June 22, 2017 10:19:57 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUN 22 2017 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	E								

AUG 03 2017

DAS
6

100

Document Control

0.00

9-89

100

DC

DOCUMENT CONTROL

0.00

Doc.Control -USB or Paperwork

Memo

record fwd angle: 89.9°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
28
9-89

AUG 03 2017

B163170 R+1

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Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.15							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 89.9								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail J to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

2017/07/03
AP [Signature]

B6 17-07-03

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 Start Date: 6/22/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/5/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	A/R Aluminum Rod batch: MB0920 9- Grind welds flush as per Dwg D2750			786170703					
120 *120* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							DAS 38 9-89 JUL 04 2017
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02							DAS 38 9-89 JUL 04 2017

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Cust Item ID:

Required Date: 7/5/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

OC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.70

Hand Finishing

DA
10
9-8

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.01

Quality Control

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Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.93

1- Open up holes of Detail L using hole saw and ground handling to 0.625"
(total of 8 holes per side) as per dwg D2750.2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float holes using uni-bit to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750
(welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI015, let cure for 12hrs.

A/R Sikaflex-291

batch: M137526exp. date: 18-04-21

2017/07/06

AP

ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 9)

A/R Aluminum Rod

batch: M137133

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

1 2.07-18
D1AP
17.07.06
D1

28617-07-11

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11- Spot face ground handling holes section (total of 4 places per side) as per
dwg D275012- Deburr holes, ensure tube is free of all scratches before sending to
paint.

170

170

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo

0.00

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.02

VERIFY C'BOARD IS GOOD

DAS
38
9-89

JUL 13 2017

DAS
38
9-89

JUL 13 2017

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190	Pressure Wash per QSI005 4.3	0.00							
190	HandFinish	0.41							
Hand Finishing	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								

200	Spray Painting per QSI005 4.2	0.00							
200	SprayPaint	0.43							
Spray Painting	Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>137195</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>137852</u>								

210	QC14- Inspect Spray Paint	0.00							
210	QC	0.00							
Quality Control	Memo Inspect for foreign object per QSI 024								

KI 6 20170728
BEB

1 41 9-89
JUL 30 2017

IRH q 90 12/08/01 **68-6**
SL
SVA

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1

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Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Assemble as per dwg HandFinishing	0.00							
230	HandFinish	Memo							
Hand Finishing	1-Install inserts as per dwg D2750	1.11							
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M1377946</u> EXP DATE: <u>1803</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M135477</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M1132690</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	Memo							
Quality Control		0.02							

DAS

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9-89

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Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.01							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.03							
Quality Control									
270	Identify as per dwg & Stock Location: _____	0.00							
270									
Packaging	Packaging	0.00							
Packaging	Memo								
	Packaging as per PPP D350-636-012								
	Location: FG072								

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Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.10

Quality Control



AUG 04 2017

Picklist Print

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 172.0000 8 8

D2743

Crossbolt Spacer

**

BE17-07-11

Location

Loc Qty

Loc Code

LG001

172

59308

62

160400

110

8

D3490-3

Manufactured No

160 Each

83.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE17-07-11

Location

Loc Qty

Loc Code

LG001

83

160393

83

4

D3490-1

Manufactured No

160 Each

95.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE17-07-11

Location

Loc Qty

Loc Code

LG001

95

160394

95

4

D3631-1

Manufactured No

230 Each

159.0000

8

8

D3631-1

Washer

**

all 17/08/01

Location

Loc Qty

Loc Code

FP001

159

159502

59

160124

100

X 8

Picklist Print

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Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 20.0000 1 1

D3791-1

Wearpad

**

all 12/08/01

Location

Loc Qty

Loc Code

FP002

20

158753

10

161928

10

X1

D3793-3 Manufactured No 230 Each 29.0000 1 1

D3793-3

Wearplate Aft

**

all 12/08/01

Location

Loc Qty

Loc Code

FP002

29

159397

4

159871

25

X1

MS21043-6 Purchased No 230 Each 72.0000 4 4

MS21043-6

NUT

**

all 12/08/01

Location

Loc Qty

Loc Code

FG

20

103693

20

M137963

X4

FP001

12

m135470

2

m137361

10

ST302

40

m137479

40

Picklist Print

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

15.0000

1

1

D3794-1

Gasket Fwd

**

lll 12/08/07

Location

Loc Qty

Loc Code

FP001

15

142770

1

150417

2

159376

12

X1

NAS1611-010

Purchased No

230

Each

203.0000

8

8

NAS1611-010

O-RING

**

lll 12/08/07

Location

Loc Qty

Loc Code

FP001

203

m134955

7

m135603

8

m136182

4

m136836

84

X8

m137587

100

D2741

Manufactured No

250

Each

47.0000

1

D2741

Replacement Blade

**

AUG 03 2017

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

10

131616

10

ST538

37

132981

14

158915

23

DAS
28
9-89

DAS
6
9-89

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Shop Packet Print

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

403.0000

4

4

***NAS1515H3I ***

**

all 12/08/01

Washer

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

359

m127831

20

m134508

3

m135600

2

m136263

4

m137361

330

x4

ST266

4

m130726

4

NAS1611-013

Purchased

No

230

Each

174.0000

8

8

NAS1611-013

**

all 12/08/01

O-Ring

Location

Loc Qty

Loc Code

FP001

174

m137333

174

x8

Picklist Print

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 147.0000 4 4

AN3C6A

Bolt

**

all 12/08/01

Location	Loc Qty	Loc Code
FG	10	
122416	10	M138040
FP001	21	
m136295	4	
m136781	17	
OVER002	96	
m137361	96	
ST350	20	
m128704	18	
m132767	2	

NAS1149C0832R Purchased No 230 Each 49.0000 1 1

NAS1149C0832R

Washer

**

all 12/08/01

Location	Loc Qty	Loc Code
FP001	49	
m135536	49	

D3536-25 Manufactured No 230 Each 27.0000 1 1

D3536-25

Gasket Center

**

all 12/08/01

Location	Loc Qty	Loc Code
FG	3	
95328	3	
FP001	24	
146747	2	
159368	4	
162506	18	

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Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No

230 Each 13.0000 1 1

D3794-3

Gasket Aft

**

all 12/08/17

Location

Loc Qty

Loc Code

FP001

13

B163820

X1

159369

12

159924

1

AN3C5A Purchased No

230 Each 928.0000 34 34

AN3C5A

Bolt

**

all 12/08/17

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

657

M137361

657

OVER002

200

M137710

200

ST350

66

M135442

66

X34

Picklist Print

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Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

162.0000

3

3

D3537-1

Wearpad

**

ll 10/08/01

Location

Loc Qty

Loc Code

FG

11

79833

1

88562

10

FP001

151

141922

7

147593

5

154226

1

159356

38

161530

50

161531

50

B162601

x3

D3535-25

Manufactured No

230

Each

18.0000

1

1

D3535-25

Wearplate Center

**

ll 17/08/01

Location

Loc Qty

Loc Code

FG

1

148669

1

FP002

17

159879

7

161915

10

x1

D3492-3

Manufactured No

230

Each

218.0000

8

8

D3492-3

Plug

**

ll 17/08/01

Location

Loc Qty

Loc Code

FP001

218

159296

136

162347

82

x8

Picklist Print

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Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

4,974.000

38

38

NAS1149C0332R

**

WASHER

Location

Loc Qty

Loc Code

FP001

1470

m137597

1470

GA

508

m133284

22

m136444

486

ST260a

2000

m135408

0

m136741

0

m137851

2000

ST266

996

m137381

996

D3488-042

Manufactured

No

230

Each

3.0000

1

1

D3488-042

**

Blade Fitting RH

Location

Loc Qty

Loc Code

FP001

3

158787

3

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Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

124.0000

1

1

AN8C35A

Bolt

**

all 17/08/01

Location

Loc Qty

Loc Code

FG

3

121275

3

FP001

121

m133336

1

m134130

1

m134133

7

m137203

112

X1

MS21083C8

Purchased

No

230

Each

63.0000

1

1

MS21083C8

Nut

**

all 17/08/01

Location

Loc Qty

Loc Code

FP001

18

m137412

18

ST297

45

m137361

25

m137820

20

X1

D2745

Manufactured

No

230

Each

182.0000

8

8

D2745

Bushing

**

all 17/08/01

Location

Loc Qty

Loc Code

FP001

182

159297

82

161760

100

X2

Picklist Print

Thursday, June 22, 2017 10:20:01 AM

Work Order ID: 163170

163170

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

376.0000

4

4

**

Handwritten signature

AN6C44A

Bolt

Location

Loc Qty

Loc Code

FP001

78

m132556

78

Handwritten: KH

over009

250

m137055

250

ST333

48

m136658

48

D3532-1

Manufactured

No

250

Each

45.0000

2

2

**

AUG 03 2017

DAS 6 9-89

DAS 26 9-89

D3532-1

Spacer

Location

Loc Qty

Loc Code

ST038

45

159312

45

Handwritten: 2

MS21083C8

Purchased

No

250

Each

63.0000

2

2

**

AUG 03 2017

DAS 6 9-89

DAS 26 9-89

MS21083C8

Nut

Location

Loc Qty

Loc Code

FP001

18

m137412

18

ST297

45

m137361

25

m137820

20

Handwritten: 2

Picklist Print

Page 14

Thursday, June 22, 2017 10:20:01 AM

Work Order ID: 163170

163170

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

302.0000

2

2

AN8C21A

Bolt

**

DAS
26
9-89

DAS
6
9-89

AUG 03 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

4

123966

2

m132169

2

over004

217

m137162

217

ST332

81

m136262

1

m137162

80

2

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALDINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2, 1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3, 5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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 NO. 163170 MWS

1706-22

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 2013-08-13
 WP

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN C1-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 06-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H4L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

REV. G

SHEET 1 OF 11

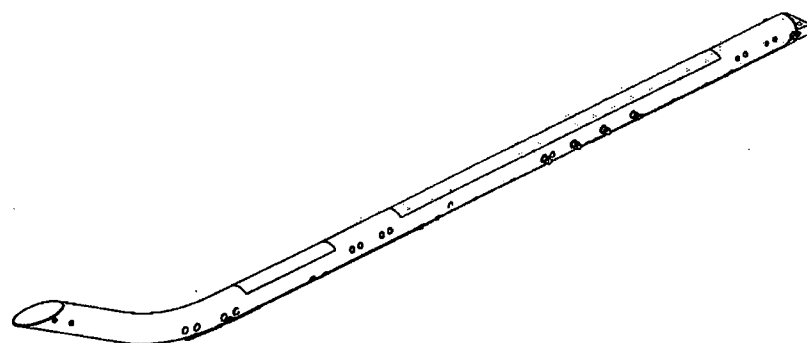
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350 SKIDTUBE ASSEMBLY

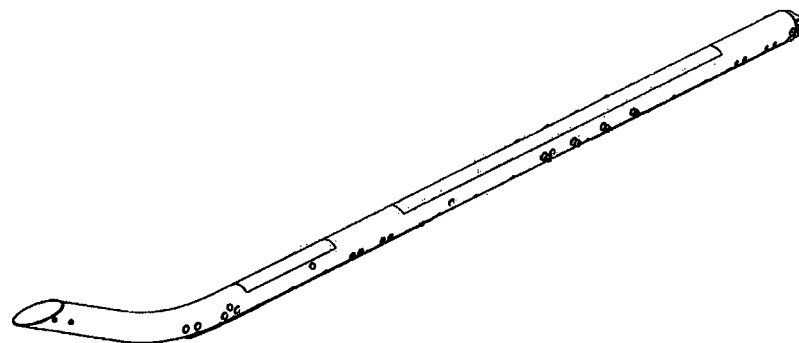
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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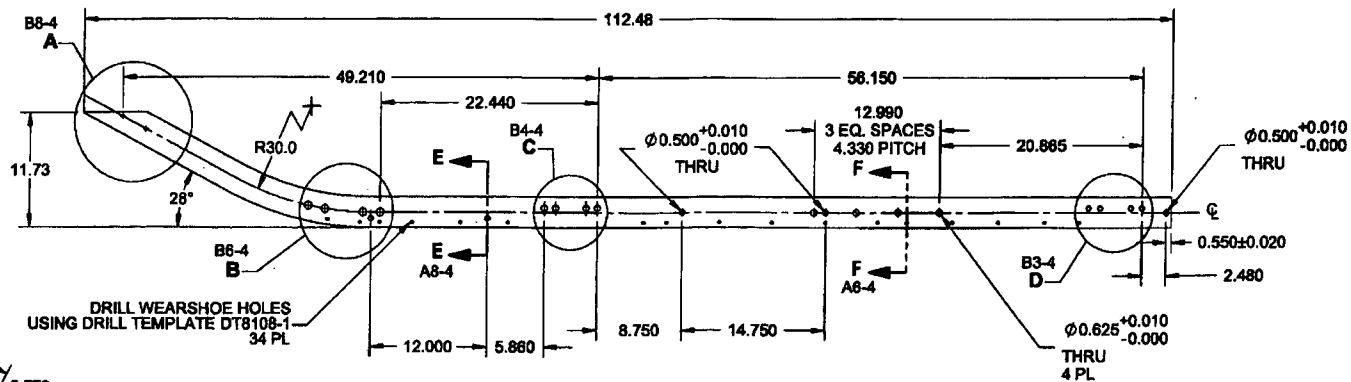
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DATE	13.07.11		

D2750-043 350 SKIDTUBE ASSEMBLY, LH

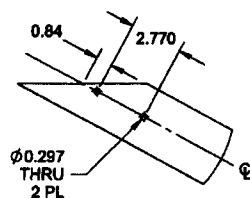
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
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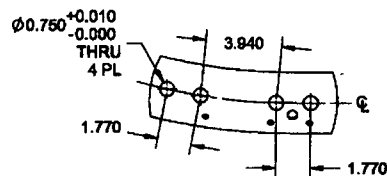
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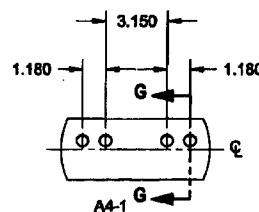
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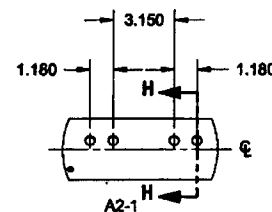
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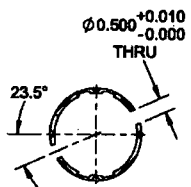
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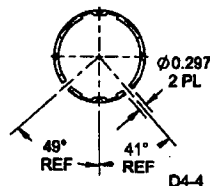
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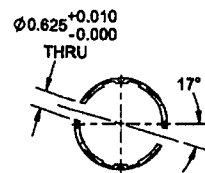
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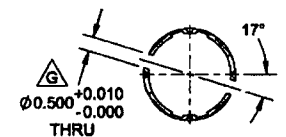
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SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

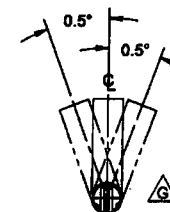
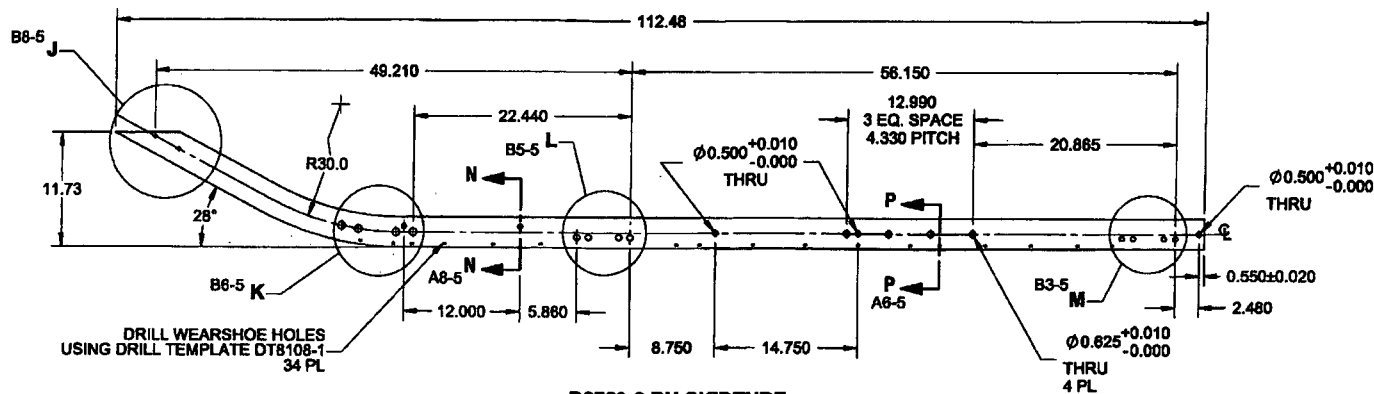


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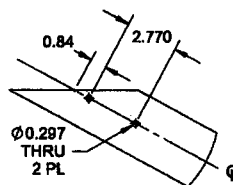
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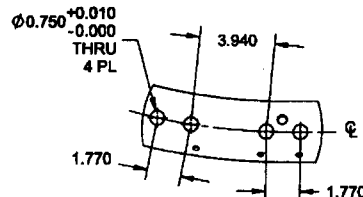


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

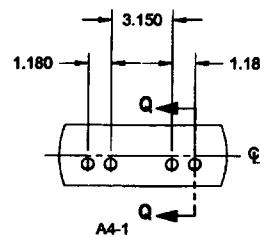
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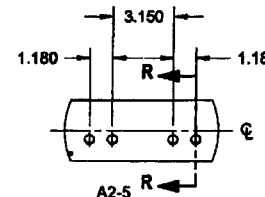
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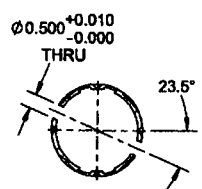
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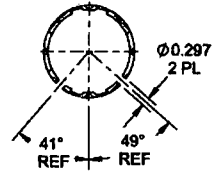
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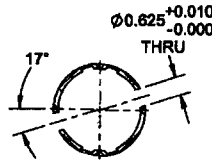
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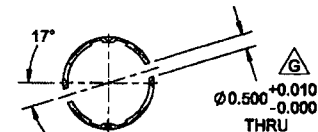
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
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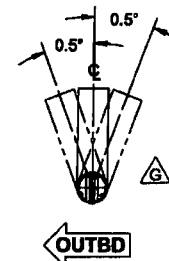
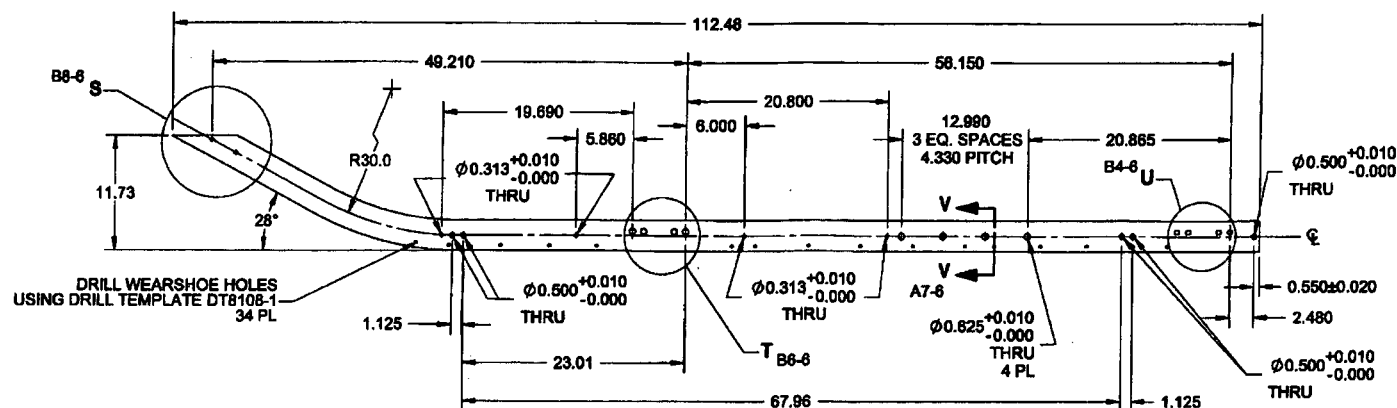


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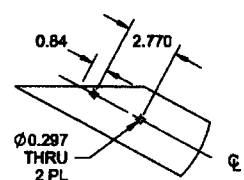
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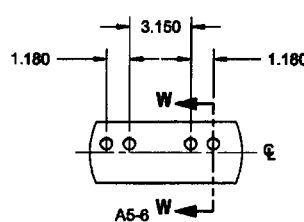


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TWIST ON FWD BEND
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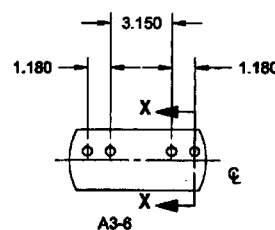
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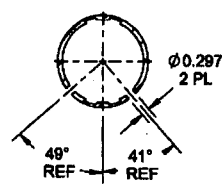
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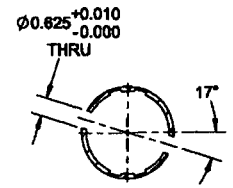
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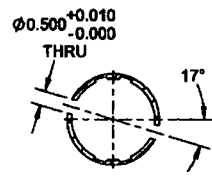
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

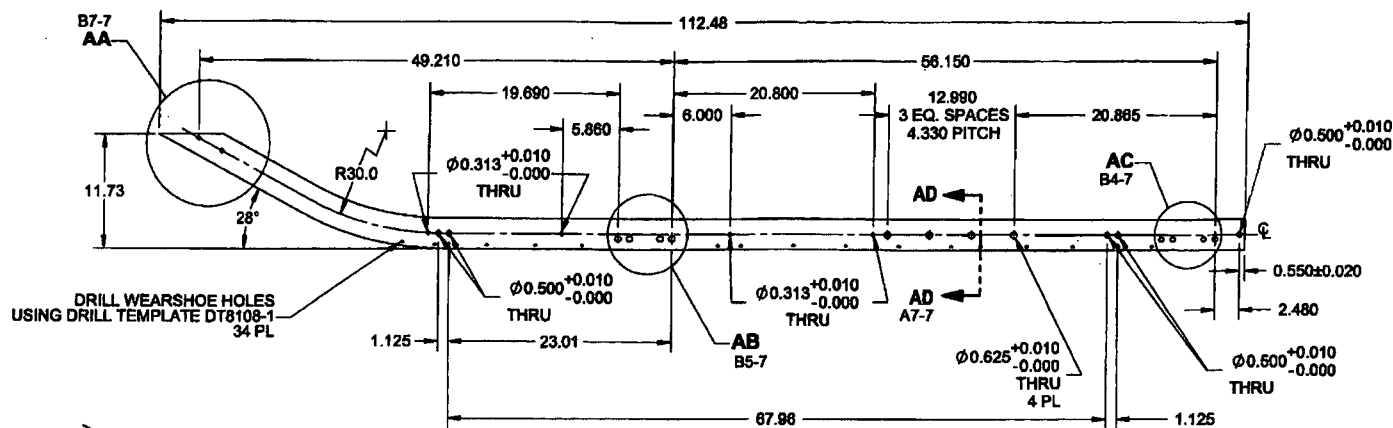


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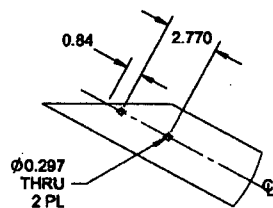
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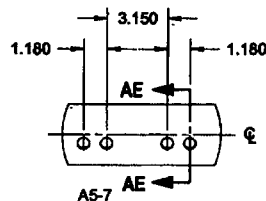
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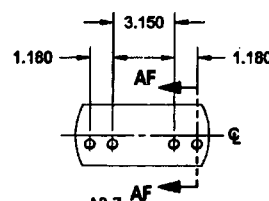
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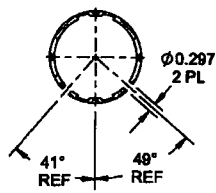
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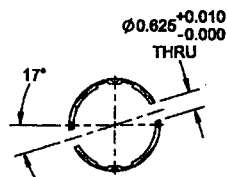
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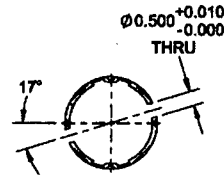
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SECTION AD-AD
SCALE 3X, 17 PL



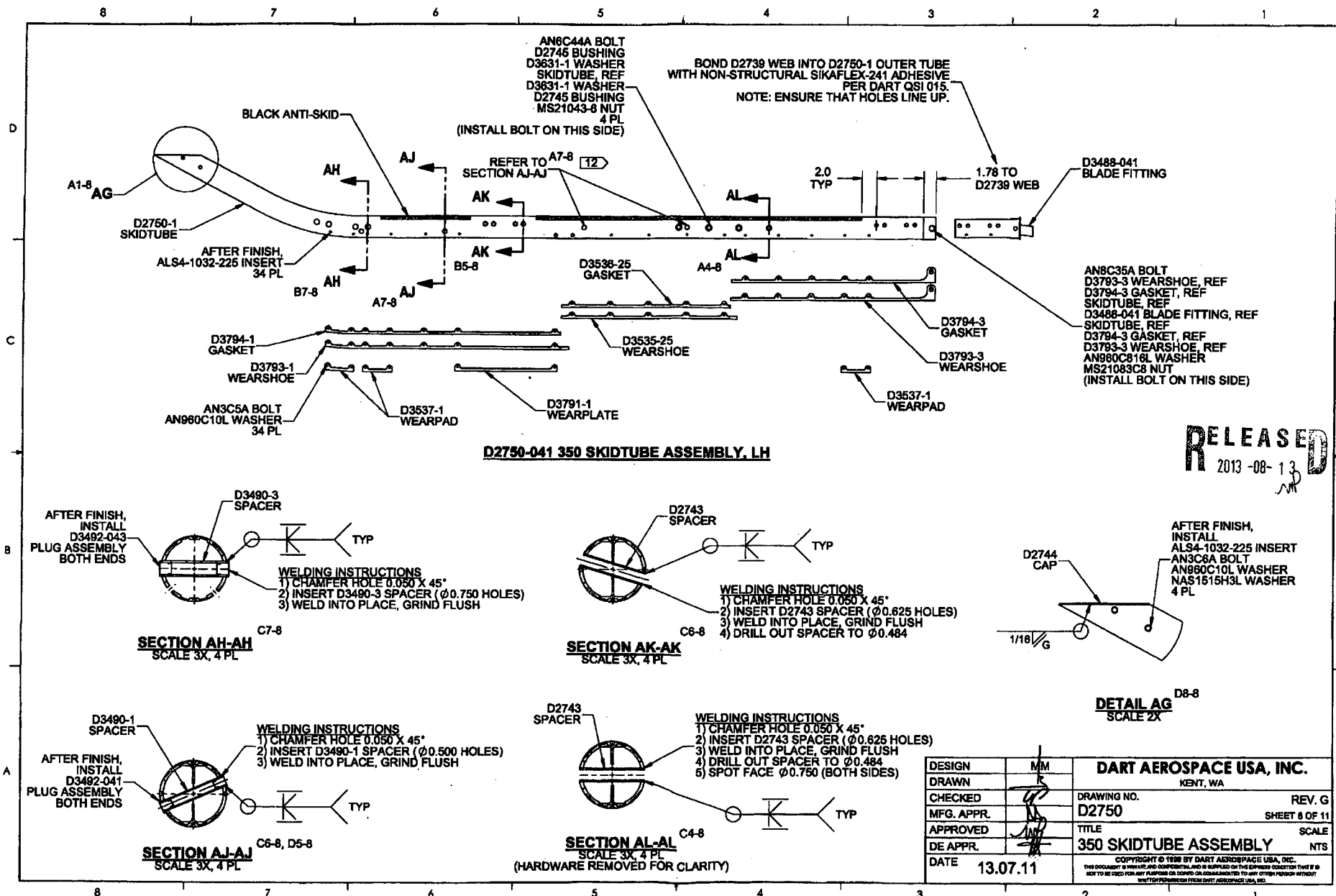
SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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2013-08-13
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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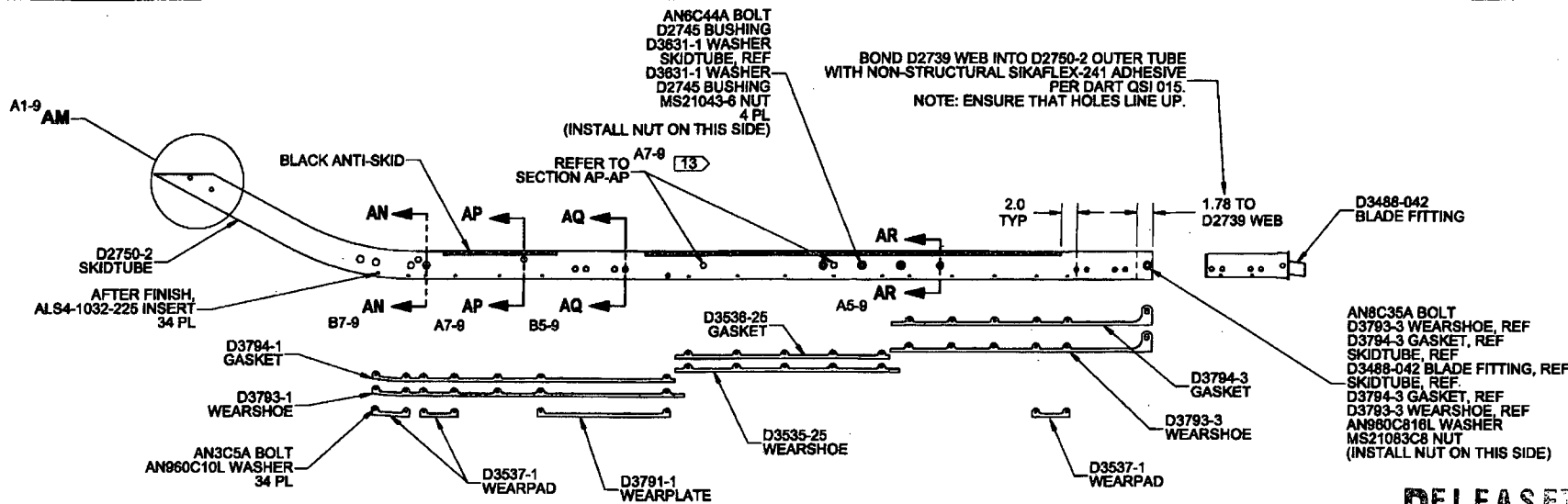


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MFG. APPR.		SHEET 8 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	
DATE	13.07.11	NTS	

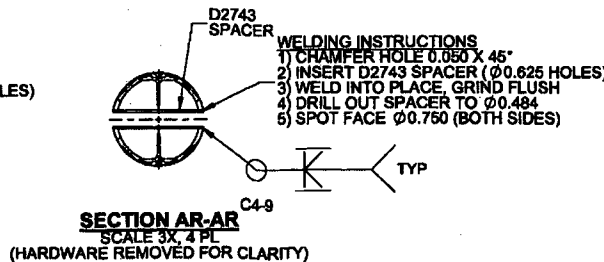
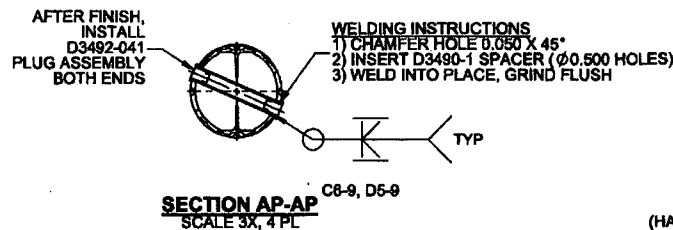
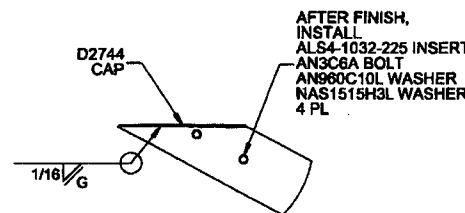
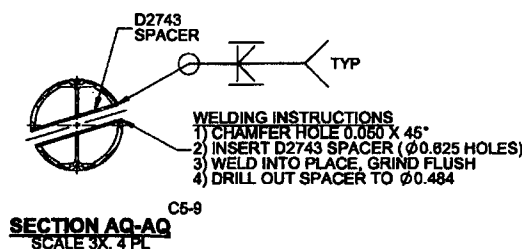
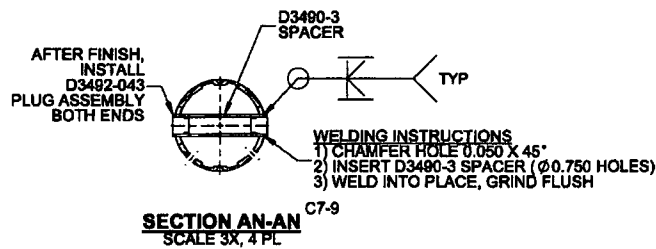
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8 7 6 5 4 3 2 1



D2750-042 350 SKIDTUBE ASSEMBLY, RH

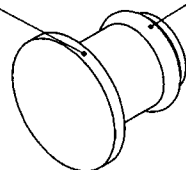
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D3492-XX PLUG
(SEE TABLE)

NAS1611 O-RING
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

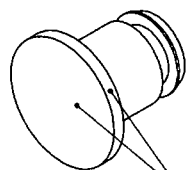
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION
X								D3492-041	PLUG ASSEMBLY
	X							D3492-043	PLUG ASSEMBLY
		X						D3492-045	PLUG ASSEMBLY
			X					D3492-047	PLUG ASSEMBLY
				X				D3492-049	PLUG ASSEMBLY
					X			D3492-051	PLUG ASSEMBLY
						X		D3492-053	PLUG ASSEMBLY
							X	D3492-055	PLUG ASSEMBLY
1								D3492-1	PLUG
	1							D3492-3	PLUG
		1						D3492-5	PLUG
			1					D3492-7	PLUG
				1				D3492-9	PLUG
					1			D3492-11	PLUG
						1		D3492-13	PLUG
							1	D3492-15	PLUG
		1						NAS1611-005	O-RING
			1					NAS1611-007	O-RING
1								NAS1611-010	O-RING
						1		NAS1611-012	O-RING
	1							NAS1611-013	O-RING
					1		1	NAS1611-015	O-RING
				1				NAS1611-016	O-RING

NOTES:

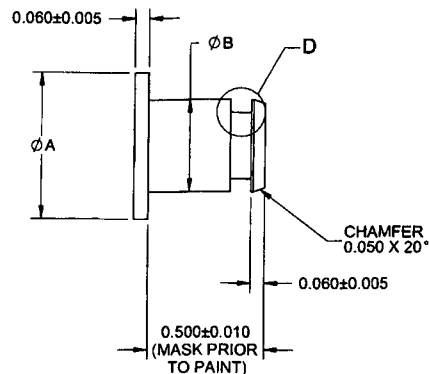
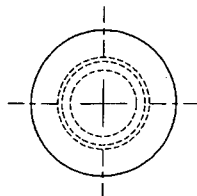
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

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2013-11-13

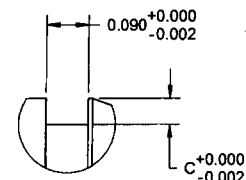
E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	AS	D3492	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	PLUG	NTS
DATE	13.08.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO. D3492	REV. E SHEET 2 OF 2
MFG. APPR.	AS	TITLE PLUG	SCALE 4:1
APPROVED	AP	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	AP		
DATE	13.08.08		

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- 2013-11-13

163170

Thurs

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 6/22/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/5/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: JUN 22 2017

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2750-042	G
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D3492	E
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AUG 03 2017

100

Document Control

0.00

DAS

5

AUG 03 2017

100

DOCUMENT CONTROL

8-89

DC

Memo

0.00

Doc.Control -USB or Paperwork

record fwd angle: 89.9°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

United States of America
Department of Transportation - Federal Aviation Administration

Supplemental Type Certificate

Number SR00646SE

This certificate, issued to

Dart Aerospace USA, Inc.
190 S. Danebo Ave.
Eugene, OR 97402

*certifies that the change in the type design for the following product with the limitations and conditions therefore as specified hereon meets the airworthiness requirements of Part * of the * Regulations.*

Original Product—Type Certificate Number:

Make:

Model:

* See attached Federal Aviation Administration (FAA) Approved Model List (AML) SR00646SE for approved aircraft models and applicable airworthiness regulations

Description of the Type Design Change: Replacement of the original landing gear skid tubes with DART D350-636 skid tube system components as appropriate. The D350-636 skid tube system must be fabricated in accordance with DART Aerospace USA, Inc. Master Document List (MDL) No. MDL-D350-636, Revision N, dated September 01, 2010, or later Federal Aviation Administration (FAA) approved Revision. The skid tubes must be installed in accordance with DART Aerospace Installation Instructions No. INN-D350-636, Revision H, dated July 26, 2010, or later FAA accepted revision. This modification must be maintained in accordance with DART Aerospace Instructions for Continued Airworthiness (ICA) No. ICA-D350-636, Revision 1, or later FAA-approved revision.

Limitations and Conditions: Approval of this change in type design applies to rotorcraft listed on the Approved Model List (AML) only. This approval should not be extended to other rotorcraft of these models on which other previously approved modification are incorporated unless it is determined by the installer that the relationship between this change and any of those other previously approved modifications, including changes in type design, will introduce no adverse effect upon the airworthiness of the rotorcraft.

A copy of this Certificate, AML No. SR00646SE, and the ICA must be maintained as part of the permanent records for the modified rotorcraft.

If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.

This certificate and the supporting data which is the basis for approval shall remain in effect until surrendered, suspended, revoked, or a termination date is otherwise established by the Administrator of the Federal Aviation Administration.

Date of application: April 24, 1998

Date reissued: October 28, 2015

Date of issuance: November 19, 1998

Date amended: September 27, 2010



By direction of the Administrator

[Signature]
(Signature)

[Title]
Manager, Seattle Aircraft Certification Office
(Title)

Any alteration of this certificate is punishable by a fine of not exceeding \$1,000, or imprisonment not exceeding 3 years, or both.

This certificate may be transferred in accordance with FAR 21.47.